

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003890**Date Inspected:** 13-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2000**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	NA			<b>CWI Present:</b>	Yes	No	
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A

**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	OBG & Tower Subassemblies	NA	NA	QAMT

**OBG**

Bay 7: Caltrans QA inspector performed magnetic particle testing (MT) per ZPMC notification of witness inspection document, dated September 13, 2008, document number 01026. The subassemblies are identified as OBG corner plates SEG-014D (weld #010), SEG-014E (weld #009), CA002 (weld #067), CA004 (weld #016), CA012 (weld #020), CA008 (weld #027), CA004 (weld #051), SEG-020E (weld #068), CA012 (weld #055), CA010 (weld #017), CA002 (weld #043) cover pass welds. The inspected welds were in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated September 13, 2008 for additional information.

**Tower**

Bay 8: Caltrans QA inspector performed magnetic particle testing (MT) per ZPMC notification of witness inspection document, dated September 13, 2008, document number 0001029. The subassemblies are identified as tower diaphragm flange subassembly SSD1-SA126A (weld #56, 63, 64), WSD1-SA110A (weld #59, 62, 64), SSD1-SA126B (weld #56, 63, 64) cover pass welds. The inspected welds were in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated September 13, 2008 for additional information. The following digital picture illustrates subassembly tower diaphragm flange ring.

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## WELDING INSPECTION REPORT

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### Summary of Conversations:

As identified with in the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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